

Work Order ID 133009

Friday, May 22, 2015 11:42:03 AM

133009

Page 1

Item ID: PB67-43001-21

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Blade Support And Cover Assembly

Start Date: 5/22/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/5/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: ymf

Date: 15-5-27

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
B67-43001-21	Rev C								

100 0.00

100

Small Fab

Small Fab

Memo

Small Fab

Assemble as per dwg PB67-43001

0.00

JUN 23 2015

DAS
24
9-89

2

JUN 23 2015

DAS
24
9-89

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

Quality Control

0.00

② 15-06-24

DAS
9
9-89

120

Identify as per dwg & Stock Location: WA3

0.00

120

Packaging

Memo

Packaging

LOCATION: WA003

0.00

2 JUN 24 2015

DAS
24
9-89

Work Order ID 133009***133009***

Page 2

Friday, May 22, 2015 11:42:03 AM

Item ID: PB67-43001-21

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Blade Support And Cover Assembly

Start Date: 5/22/2015 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 6/5/2015 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

ML5

JUN 2 5 2015

ML5

JUN 2 5 2015

Picklist Print

Page 1

Friday, May 22, 2015 11:42:03 AM

Work Order ID: 133009

133009

Parent Item: PB67-43001-21

PB67-43001-21

Parent Item Name: Upper Blade Support And Cover Assembly

Start Date: 5/22/2015

Required Date: 6/5/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-25 new issue DD verified by:ec
10.09.28 per rev C dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-10		Purchased		No		100	Each	364.0000	10	20		DAS 06 9-89	

MS27039-1-10

SCREW

**

Location	Loc Qty	Loc Code
CA	41	
m128635	41	
GA	239	
m129541	239	
ST285	84	
m123522	2	
m130358	72	
m130388	10	

NAS1149D0316J

Purchased

No

100

Each

369.0000

10

20

**

NAS1149D0316J

Washer

Location	Loc Qty	Loc Code
GA	156	
122151	156	
ST270	213	
M127956	213	

DAS
06
9-89

JUN 23 2015

Picklist Print

Friday, May 22, 2015 11:42:03 AM

Page 2

Work Order ID: 133009

133009

Parent Item: PB67-43001-21

PR67-43001-21

Parent Item Name: Upper Blade Support And Cover Assembly

Start Date: 5/22/2015

Required Date: 6/5/2015

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0363J

Purchased

No

100

Each

2,186.000

12

24

NAS1149D0363J******

Washer

DAS
06
9-89

JUN 23 2015

LocationLoc QtyLoc Code

CA

569

m130799

569

GA

222

m128429

222

ST269

1395

m126319

9

m131618

386

m132317

1000

PB67-43001-173

Manufactured

No

100

Each

10.0000

1

2

PR67-43001-173******

Cover Plate

LocationLoc QtyLoc Code

Mezz2

10

111817

9

99994

1

PB67-43001-75

Manufactured

No

100

Each

0.0000

1

PR67-43001-75******

Upper Blade Support Ass'Y

PB67-43001-85

Manufactured

No

100

Each

15.0000

1

2

PR67-43001-85******

D-Pad Assembly, Long

LocationLoc QtyLoc Code

Mezz2

15

100025

9

111756

6

1
DAS
06
9-892
DAS
24 133 23 5 JUN 25 2015
9-89DAS
06
9-89

JUN 23 2015

2

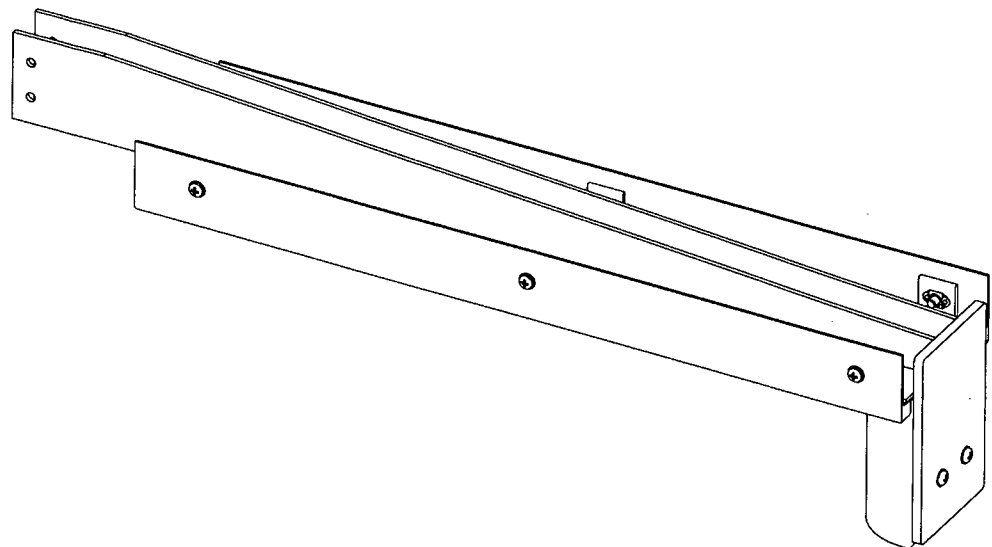
Friday, May 22, 2015 11:42:03 AM

Shop Packet Print

Page 2

8 7 6 5 4 3 2 1

ITEM	QTY -21	P/N	DESCRIPTION
1	X	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
3	1	B67-43001-75	LOWER BLADE SUPPORT ASSY
4	1	B67-43001-85	LONG D-PAD ASSY
5	1	B67-43001-173	COVER PLATE
7	10	MS27039-1-10	SCREW
8	10	NAS1149D0316J	WASHER
9	12	NAS1149D0363J	WASHER



B67-43001-21 UPPER BLADE SUPPORT AND COVER ASSY

#133009

RELEASED
2010-09-16
MP

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 10 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.07.28
REV	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		DRAWING NO.	REV. C	
CHECKED		B67-43001-21	SHEET 1 OF 2	
MFG. APPR.		TITLE	SCALE	
APPROVED		UPPER BLADE SUPPORT AND COVER ASSY	NTS	
DE APPR.	N/A	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DATE	09.07.28			

8 7 6 5 4 3 2 1

DQA: _____ Date: _____

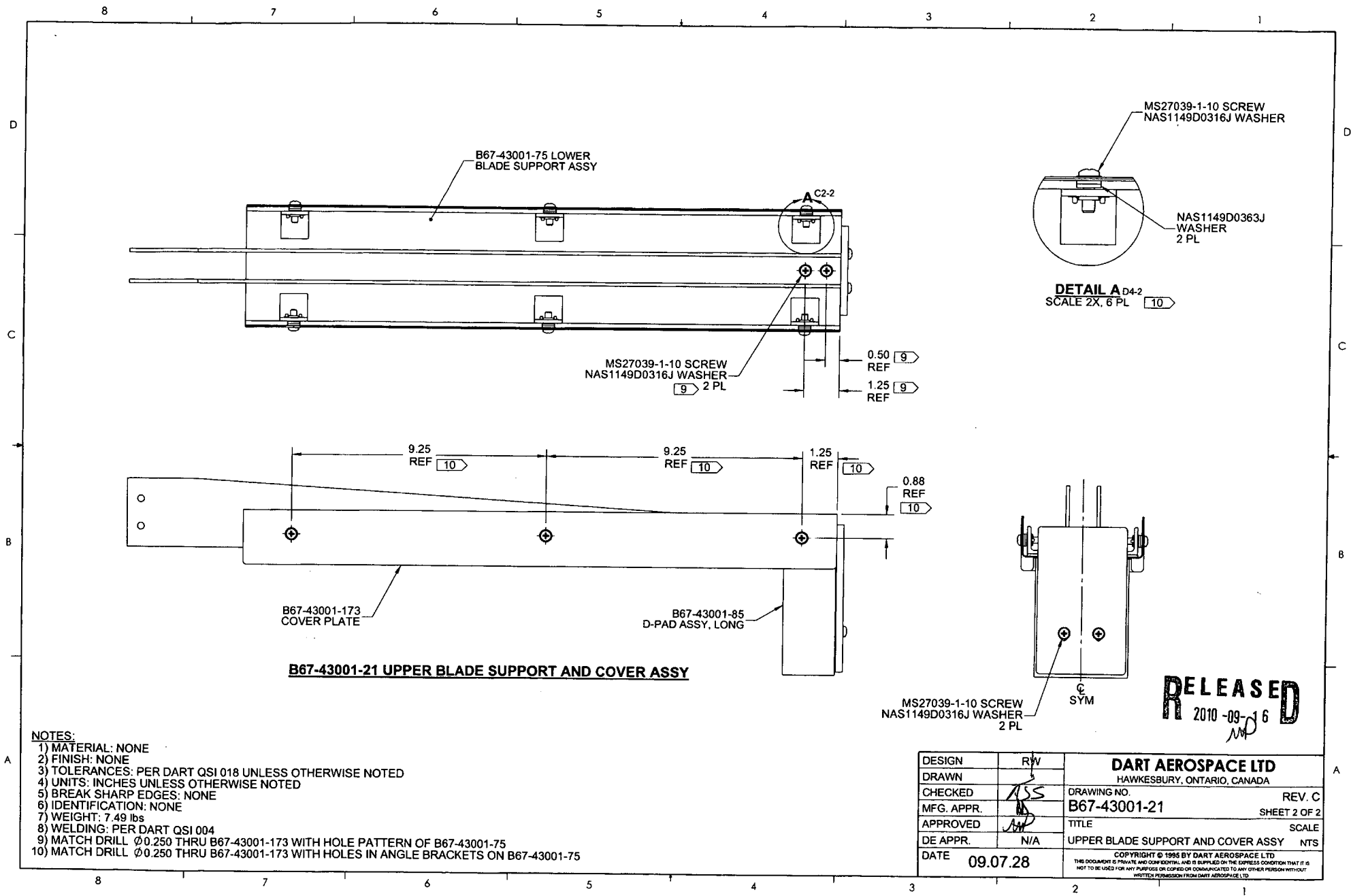


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
Root Cause				FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐															
OTHER : ☐																									



NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.49 lbs
- 8) WELDING: PER DART QSI 004
- 9) MATCH DRILL $\varnothing 0.250$ THRU B67-43001-173 WITH HOLE PATTERN OF B67-43001-75
- 10) MATCH DRILL $\varnothing 0.250$ THRU B67-43001-173 WITH HOLES IN ANGLE BRACKETS ON B67-43001-75

MS27039-1-10 SCREW
NAS1149D0316J WASHER
2 PL

DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ASS		
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	ASS	B67-43001-21	SHEET 2 OF 2
APPROVED	ASS	TITLE	SCALE
DE APPR.	N/A	UPPER BLADE SUPPORT AND COVER ASSY	NTS
DATE	09.07.28	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2010-09-16
MJD

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					